



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5377-1

Job Sheet 171995



Part No: D5377-1

Job Qty: 4 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/12/18

Job Tracking No:

Due Date: 2/15/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 16-01-08 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/14/18	0.00	0.00	Start Up Waterjet		
120	Waterjet	4 pcs		2/14/18	0.00	2.33	Waterjet1		
130	CNC Vertical Machining	4 pcs		2/15/18	0.62	10.26	HAAS1-2		kt 18-02-12
140	QC	4 pcs		2/15/18	0.00	0.00	QC2 Machining-4		kt 18-02-12
150	QC	4 pcs		2/15/18	0.00	0.00	QC8 Machining-4		kt 18-02-12
151	Packaging	4 pcs		2/15/18	0.00	0.00	Packaging3	37 430	kt 18-02-12
190	QC21-SA	4 Ea		2/15/18	0.00	0.00	QC21		FEB 21 2018

Part Op 120 - Cut Blank as per D5377-1_blank File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per FolioFB448 and Dwg

DAS
21
9-82

FEB 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	.0004 sf (.0001 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	0	670	0

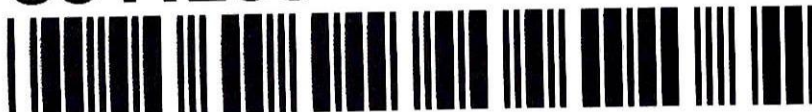
Allocated Container Detail

Qty	Serial No	Location	Init
0	S035567	start up waterjet	

DART
AEROSPACE
S041203

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Bearpaw

PART NO: D5377 - 1

Original Serial #: S041203

Revision:

Operation:

Change No:

Start up Operation 02/12/18

Job No: 171995

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.380Inches ± 0.030	0.410 0.350		
2	Bearpaw	5.000Inches ± 0.030	5.030 4.970		
3	Bearpaw	3.930Inches ± 0.030	3.960 3.900		
4	Bearpaw	1.380Inches ± 0.030	1.410 1.350		
5	Bearpaw	5.500Inches ± 0.030	5.530 5.470		
6	Bearpaw	1.720Inches ± 0.030	1.750 1.690		
7	Bearpaw	2.0Degrees ± 0.0	2.0 2.0		
8	Bearpaw	15.440Inches ± 0.030	15.470 15.410		
9	Bearpaw	4.688Inches ± 0.010	4.698 4.678		
10	Bearpaw	0.756Inches ± 0.010	0.766 0.746		
11	Bearpaw	0.700Inches ± 0.010	0.710 0.690		
12	Bearpaw	24.000Inches ± 0.030	24.030 23.970		
13	Bearpaw	21.340Inches ± 0.030	21.370 21.310		
14	Bearpaw	6.400Inches ± 0.030	6.430 6.370		
15	Bearpaw	3.520Inches ± 0.030	3.550 3.490		
16	Bearpaw	0.240Inches ± 0.030	0.270 0.210		
17	Bearpaw	0.250Inches ± 0.010	0.260 0.240	Radius	
18	Bearpaw	0.300Inches ± 0.030	0.330 0.270		
19	Bearpaw	45.0Degrees ± 0.5	45.5 44.5		
20	Bearpaw	0.500Inches ± 0.030	0.530 0.470		
21	Bearpaw	0.740Inches ± 0.030	0.770 0.710		
22	Bearpaw	0.950Inches ± 0.030	0.980 0.920		
23	Bearpaw	0.261Inches + 0.006 - 0.001	0.267 0.260		
24	Bearpaw	0.500Inches ± 0.010	0.510 0.490		
25	Bearpaw	0.060Inches ± 0.030	0.090 0.030		
26	Bearpaw	45.0Degrees ± 0.5	45.5 44.5		
27	Bearpaw	0.460Inches ± 0.010	0.470 0.450		
28	Bearpaw	0.650Inches ± 0.010	0.660 0.640		
29	Bearpaw	0.375Inches ± 0.010	0.385 0.365		



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5377-1
Job Sheet 165500



Part No: D5377-1

Job Qty: 4 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 16-01-08 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D5377-1 Bearpaw MUHMBW10 UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	DWG REV A IPP REV:A NEW ISSUE 16-01-08 JLM VERIFIED BY:DD		0.000	
			0.000	

*Cancelled
see 171995*

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	4 Ea	10/30/17	0.00	0.00	Start up container	
130	CNC Vertical Machining	4 pcs	10/31/17	0.62	10.26	HAAS 1	
140	QC	4 pcs	10/31/17	0.00	0.00	QC2	
150	QC	4 pcs	10/31/17	0.00	0.00	QC8	
151	Packaging	4 pcs	10/31/17	0.00	0.00	Packaging3	
190	QC21-SA	4 Ea	10/31/17	0.00	0.00	QC21	

Part Op Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per FolioFB448 and Dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D5377-1 B165500		16 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D5377-1 B165500	16	4	0	0

Part Specifications

Specifications could not be fo

Status: Stock

Part: **D5377-1 B165500**

Created: 9/30/17 1:14 PM DART.LAJEUNESSE.MARIE



Serial No: **S000232**

Printed By: Goldston, Justin 10/2/17 10:45 AM

Work Order Summary

Thursday, September 28, 2017 7:29:04 AM

Page 1 of 1

Criteria : Work Order ID: 165500 Item ID: D5377-1 Product Family MACHINING

Work Order Start Dates 9/1/2017 to 9/1/2017 11:59:59 PM Work Order Required Dates 9/8/2017 to 9/8/2017

11:59:59 PM

All References

Work Order Status Released

Work Order ID	165500	Required Qty	4.0000	Status Code	Released
Item ID	D5377-1	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Bearpaw				
Current Acct Value	\$452.883				

Start Date	9/1/2017	Required Date	9/8/2017	Completed Date	
Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
<u>Direct Costs</u>	<u>Total</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>
Material	\$506.400	\$0.000	\$126.601	\$126.601	100.00%
Labor	\$39.903	\$0.000	\$84.381	\$84.381	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$106.776	\$0.000	\$241.901	\$241.901	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$653.080	\$0.000	\$452.883	\$452.883	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
MUHMWB10					
UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	22.3158		8/28/2017	24.0000	\$506.400
Total Matl Amts:					\$506.400

Work Center Waterjet

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
conw01		8/27/2017										
120			0.00	0.00	1.93	1.93	1.00	\$0.000	\$39.903	\$106.776	\$0.000	\$146.680
Total:			0.00	0.00	1.93	1.93	1.00	\$0.000	\$39.903	\$106.776	\$0.000	\$146.680

Work Order ID 165500

Thursday, August 24, 2017 9:26:39 AM

165500

Page 1

Item ID: D5377-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearpaw
 Start Date: 9/1/2017 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 9/8/2017 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: DAS 21 8-22 Date: Aug 24 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5377	A								

120
 120
 Waterjet
 FLOW CNC Waterjet
 FLOW WATER JET
 Memo
 Cut Blank as per D5377-1_blank File
 0.00
 1.88

(4) 08/27/17

130
 130
 HAAS I
 HAAS CNC vertical machine #1
 HAAS CNC VERTICAL MACHINING #1
 Memo
 1-Inspect material for defects or damage prior to machining
 2-Machine as per FolioFB448 and Dwg
 FOLIO REV: AA
 DWG REV: 14
 3-Deburr
 5.28
 2.70

(4) 08/27/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Thursday, August 24, 2017 9:26:39 AM

Page 2

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Work Order ID 165500

Thursday, August 24, 2017 9:26:39 AM

165500

Page 3

Item ID: D5377-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 9/1/2017 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 9/8/2017 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.40

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Page 1

Thursday, August 24, 2017 9:26:42 AM

Work Order ID: 165500

165500

Parent Item: D5377-1

D5377-1

Parent Item Name: Bearpaw

Start Date: 9/1/2017

Required Date: 9/8/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 16-01-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No		120	sf	706.3310	5.3	22.31579			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

08/17/08/27

Location

Loc Qty

Loc Code

MAT018

706.331

m136453

200

m137448

106.331

m138127

400

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

DART AEROSPACE LTD		Work Order:	165500
Description: Bearpaw		Part Number:	D5377-1
Inspection Dwg: D5377 Rev: A		Page 1 of 1	

INSPECTION SHEET

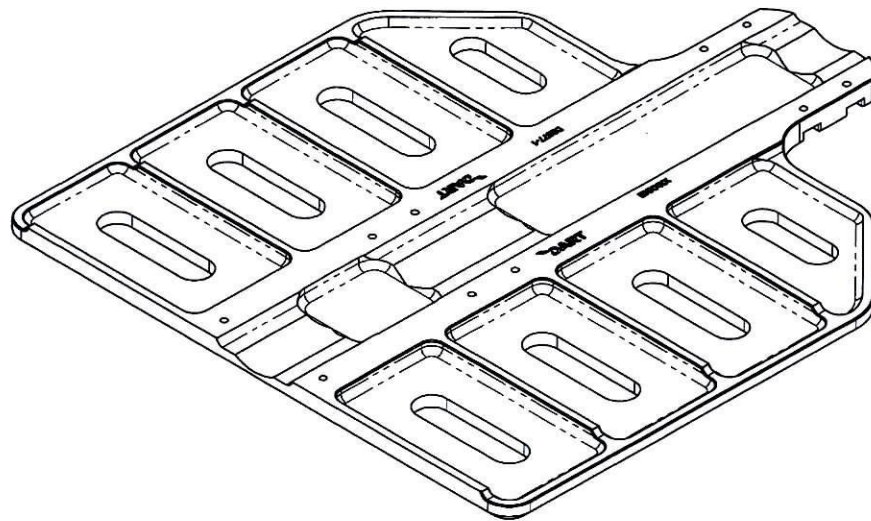
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.38	+/-0.030	0.380	✓		Kt-05	vern.
5.00	+/-0.030	5.000	✓		" "	" "
3.93	+/-0.030	3.932	✓		" "	" "
1.38	+/-0.030	1.380	✓		" "	" "
5.50	+/-0.030	5.500	✓		" "	" "
1.72	+/-0.030	1.720	✓		" "	" "
2.00	+/-0.030	2.000	✓		" "	" "
15.44	+/-0.030	15.44	✓		TAPE	
4.688	+/-0.010	4.681	✓		Kt-05	vern.
0.756	+/-0.010	0.756	✓		Kt-05	vern.
0.700	+/-0.010	0.700	✓		" "	" "
24.00	+/-0.030	24.00	✓		TAPE	
21.34	+/-0.030	21.340	✓		" "	" "
6.40	+/-0.030	6.405	✓		Kt-05	vern.
3.52	+/-0.030	3.510	✓		" "	" "
0.24	+/-0.030	0.240	✓		" "	" "
R0.250	+/-0.010	0.250	✓		R-G	
0.30 x 45°	+/-0.030 x +/-0.5°	0.300 x 45°	✓		Kt-05	vern.
0.50	+/-0.030	0.490	✓		" "	" "
0.74	+/-0.030	0.734	✓		" "	" "
0.95	+/-0.030	0.945	✓		" "	" "
Ø0.261	+0.006/-0.001	0.261	✓		" "	" "
0.500	+/-0.010	0.505			" "	" "
0.06 x 45°	+/-0.030 x +/-0.5°	0.060 x 45°	✓		Kt-05	vern.
0.460	+/-0.010	0.460	✓		" "	" "
Ø0.650	+/-0.010	0.650	✓		" "	" "
0.375	+/-0.010	0.375	✓		" "	" "

DAS

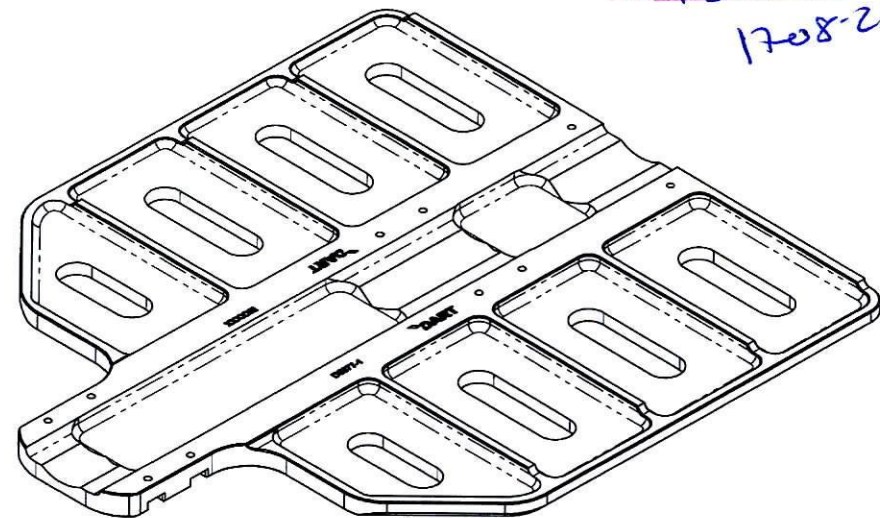
Measured by: KT 9-89	Checked by: [Signature]	QC Inspector:
Date: 18-02-11	Date: 18/02/16	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	16.03.30	New Issue	KJ [Signature]	[Signature]



D5377-1 BEARPAW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165500 115
1708-24

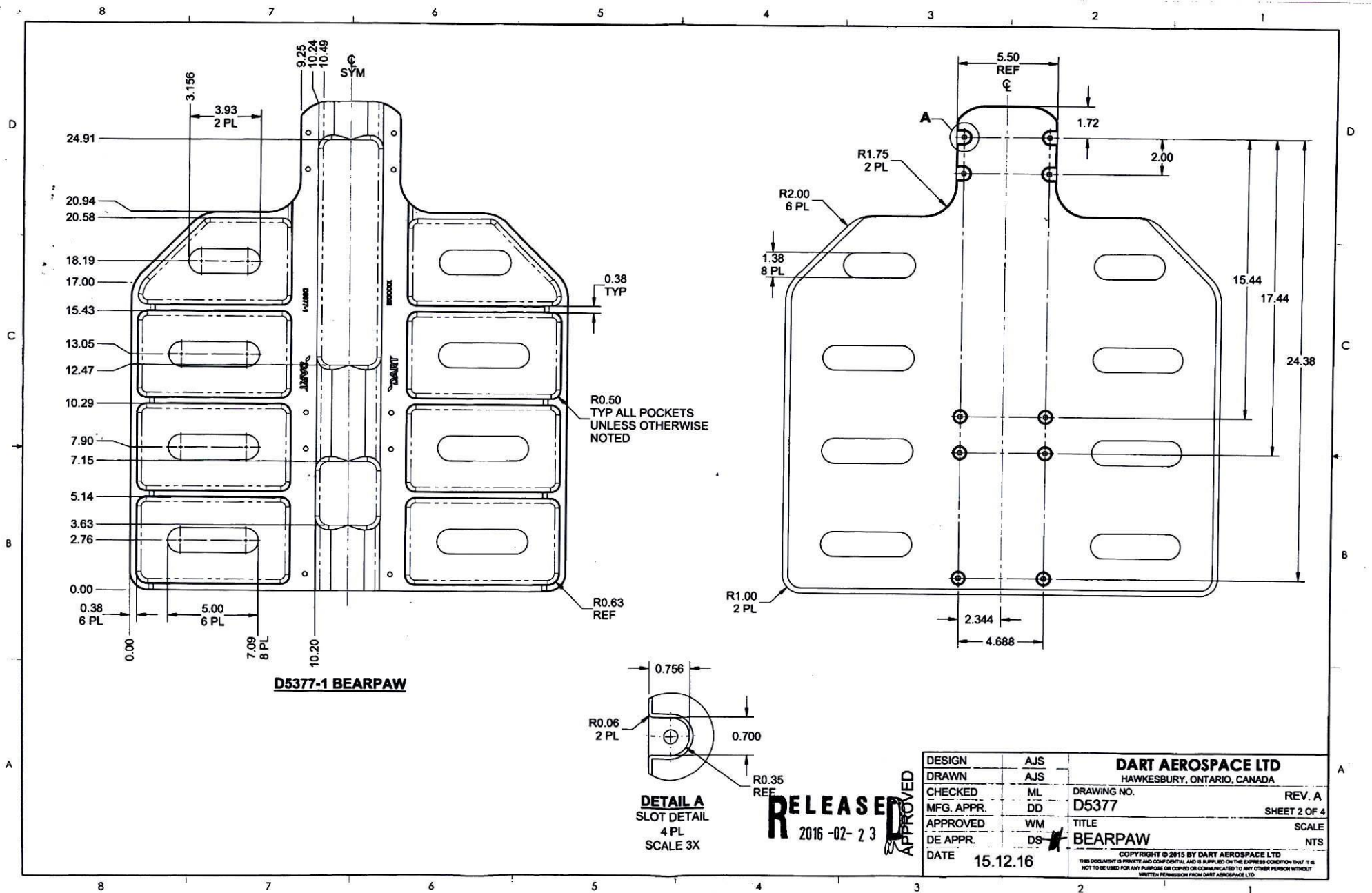
NOTES:

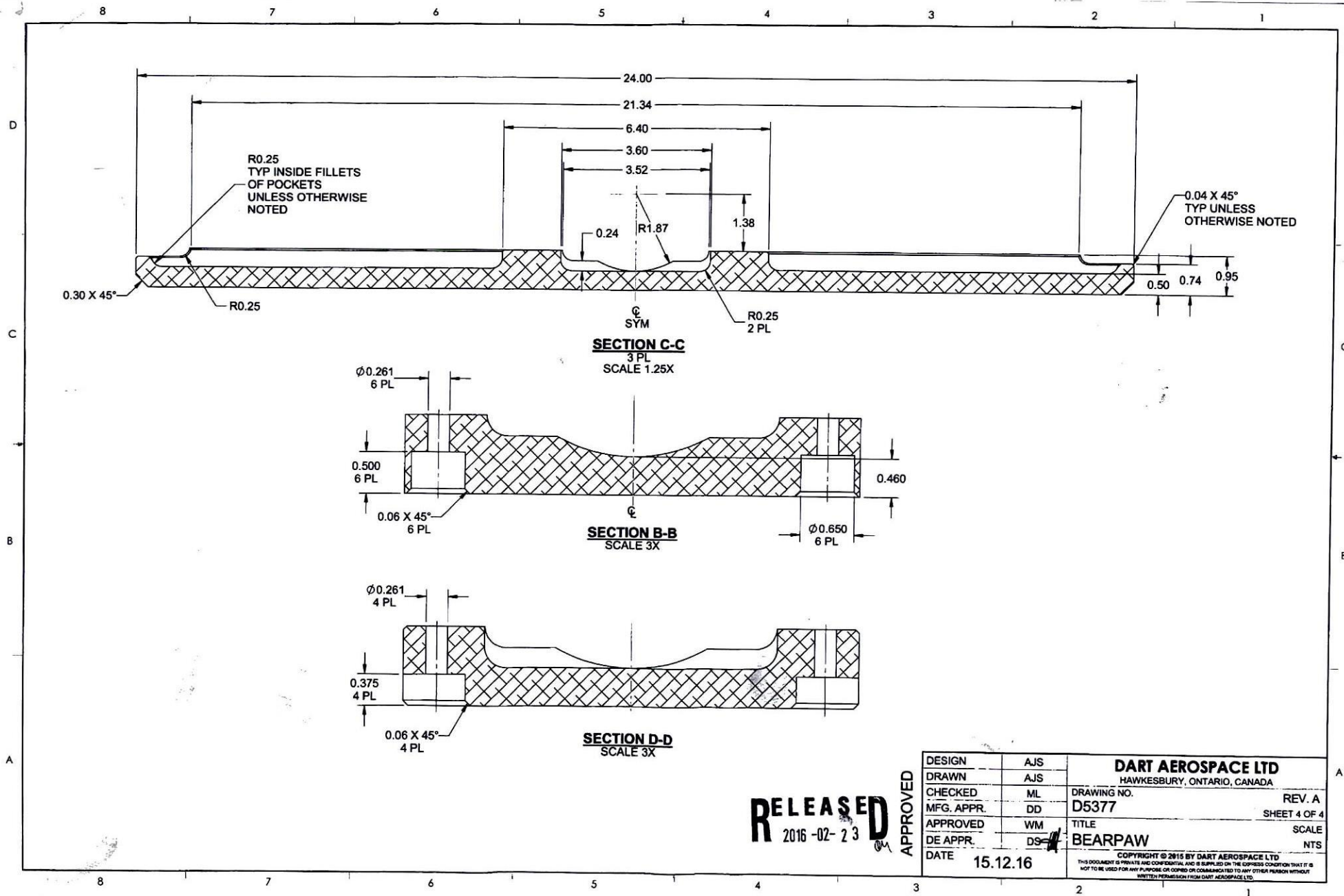
- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMB100
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD
- 7) WEIGHT: 9.55 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE D5377-1-REVA.STP

RELEASED
2016-02-23
EN 16-529

APPROVED

A NEW ISSUE		AJS	15.12.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5377 BEARPAW COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	ML		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS	REV. A SHEET 1 OF 4 SCALE NTS	
DATE	15.12.16		





RELEASED
2016-02-23

APPROVED